

Work Order ID 133386

Monday, June 08, 2015 3:59:42 PM

133386

Page 1

Item ID: D4956-23 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Center Fwd
 Start Date: 6/08/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 6/08/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: ML3 Date: JUN 09 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4956	A

100

0.00

100

Waterjet

FLOW CNC Waterjet

304-040

Memo

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

6 Ø Jm15-6-11

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

6 Ø Jm15-6-11

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(6)			DAS 38 9-89 JUN 17 2015
130 *130* Brake NC Brake NC	Form as per dwg Memo FORM JOGGLE AS DWG	0.00 0.00				6x			DAS 36 9-89 15/06/15
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				(6)			DAS 38 9-89 JUN 16 2015

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Work Order update only ☐

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150						<u>6</u>			
HandFinish	Memo	0.00							
Hand Finishing	1- After finish, coat entire top (concave) surface as per note 2 dwg D4956. TEXTURED COATING B#: <u>132115</u>								<u>CN 15-06-16</u>
160	QC3- Inspect Part Finish	0.00							
160						<u>(6)</u>			<u>DAS</u>
QC	Memo	0.00							<u>38</u>
Quality Control									<u>9-89</u>
									<u>JUN 17 2015</u>
170	Identify as per dwg & Stock Location: <u>FP-002</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging	LOCATION : FP001								<u>x 6 / All 15/06/17</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation		Disposition			

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
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180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLS

JUN 18 2015

MLS

JUN 18 2015

DQA: _____ Date: _____



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Picklist Print

Monday, June 08, 2015 3:59:42 PM

Page 1

Work Order ID: 133386

133386

Parent Item: D4956-23

D4956-23

Parent Item Name: Wearplate Center Fwd

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S20GA

Purchased

No

sf

402.9623

8

M304S20GA

**

Jm15-6-11

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT

43.2

m131700

43.2

MAT020

359.7623

m130345

1.5139

m131060

102.2484

m132387

256

131060

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Root Cause				FAULT CATEGORY																																																																					
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DART AEROSPACE LTD		Work Order:	133386
Description: Wearshoe		Part Number:	D4956-23
Inspection Dwg: D4956 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.188	+0.005/-0.001	0.190"	-		✓	Jkmo1
0.300	+/-0.010	0.302"	-		✓	
0.300	+/-0.010	0.305"	-		✓	
1.885	+/-0.010	1.885"	-		✓	
2.000	+/-0.010	2.000"	-		✓	
6.750	+/-0.010	6.750"	-		✓	
11.500	+/-0.010	11.500"	-		T	Jkmo7.
16.750	+/-0.010	16.750"	-		T	
25.140	+/-0.010	25.140"	-		T	
30.530	+/-0.010	30.530"	-		T	
35.920	+/-0.010	35.920"	-		T	
41.310	+/-0.010	41.310"	-		T	
46.700	+/-0.010	46.700"	-		T	
50.200	+/-0.010	50.200"	-		T	
54.850	+/-0.010	54.850"	-		T	
56.85	+/-0.030	56.85"	-		T	
6.00	+/-0.030	6.00"	-		✓	
14.00	+/-0.030	14.00"	-		T	
22.00	+/-0.030	22.00"	-		T	
30.00	+/-0.030	30.00"	-		T	
38.00	+/-0.030	38.00"	-		T	
45.00	+/-0.030	45.00"	-		T	
54.00	+/-0.030	54.00"	-		T	

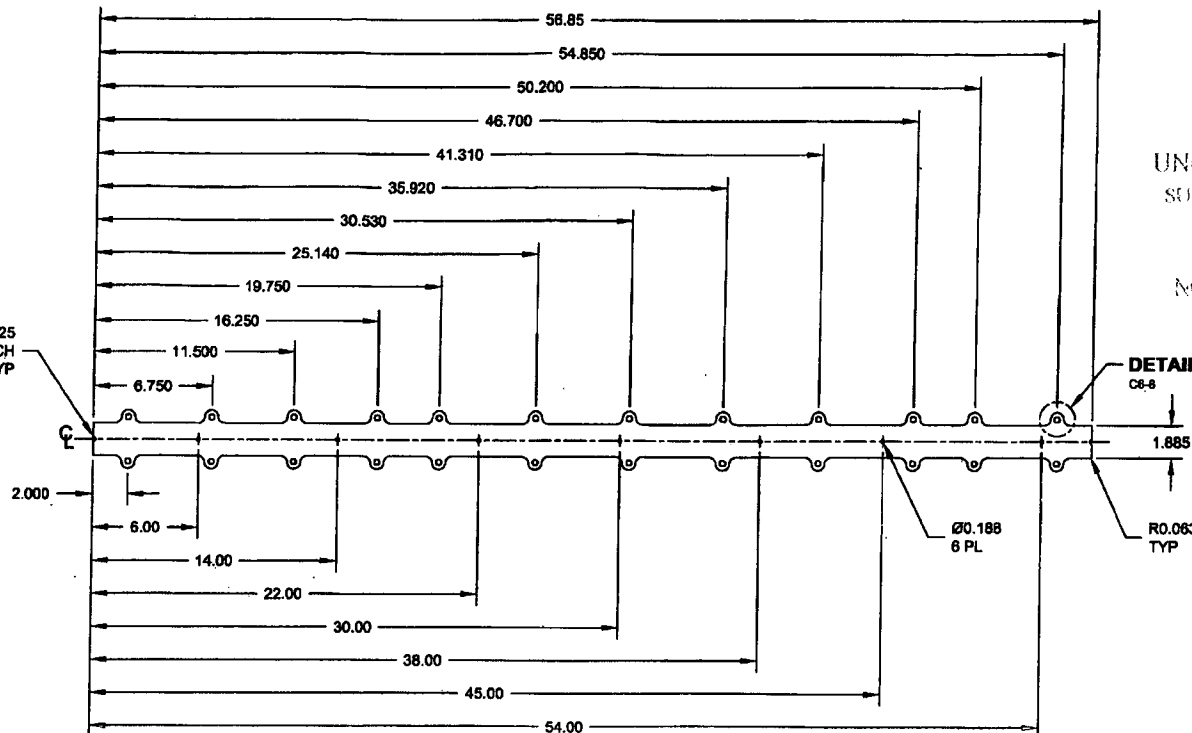
Measured by:	Jm	Audited by:	DAS 38 9-89	Preliminary Approval:	
Date:	15-6-11	Date:	JUN 12 2015	Date:	

Rev	Date	Change	Revised by	Approved
A	14.08.27	New Issue	KJ	

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WITHOUT NOTICE
WORK ORDER

NO. 133386-415
15-06-09

R0.25
TOOLING NOTCH
TYP



D4956-23F FLAT PATTERN



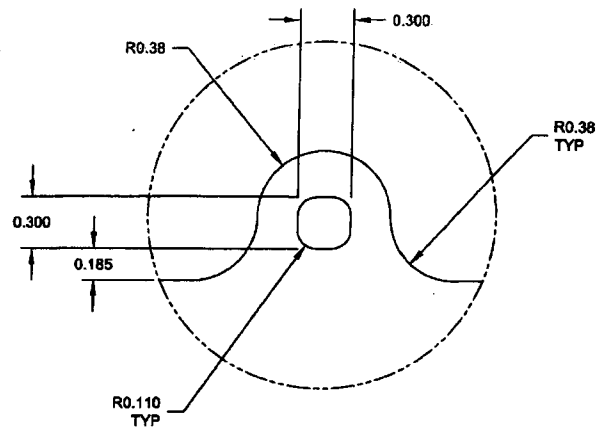
D4956-23 WEARSHOE
(MAKE FROM D4956-23F)

NOTES

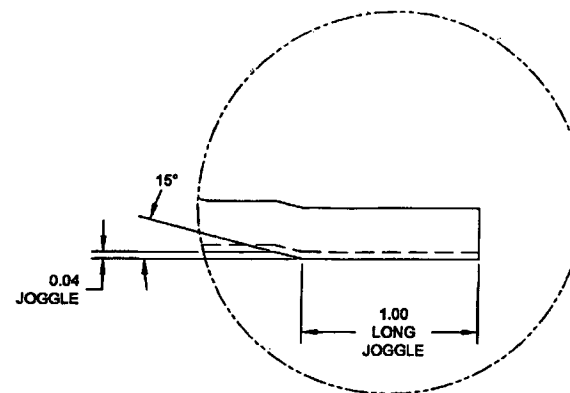
- 1) MATERIAL: AISI 304/316 SS SHEET, 0.038 THICK (20 GAUGE)
PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020-0.040 THICK, PER DART QSI 005 4.9
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N AND B/N PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 1.29 lbs
- 8) SYMMETRY: ABOUT CENTERLINE

RELEASED
2014-04-17

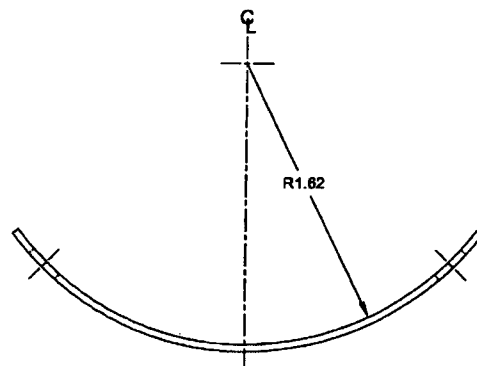
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	BB	D4956	SHEET 4 OF 8
APPROVED	AP	TITLE	SCALE
DE APPR.		WEARSHOE	NTS
DATE	13.09.26	COPYRIGHT © 2013 BY DART AEROSPACE LTD	
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DETAIL A C8-1 C4-1
C8-2
C8-3 C1-3
C2-4
C8-5 C2-5
C8-6 C2-6
C4-7 C3-7



DETAIL B B6-1 B2-1
B3-2
B5-3 B1-3
B2-4
B4-7 B1-7



SECTION C-C B7-1 B3-1
B5-2
B7-3 B3-3
B6-4
B7-5 B3-5
B7-6 B3-6
B7-7 B3-7

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